

5/15

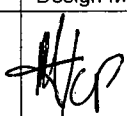


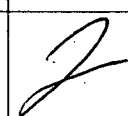

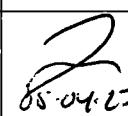
DART AEROSPACE LTD	Work Order:	22501
Description: Bracket	Part Number:	D3145-2
Dwg: D3145 Rev. B	Qty:	11 10 11
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	FA	05.02.21	10
2	MV	Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2.000x2.000 Batch: M17124	RG	05/04/07	10
3	MV	Machine per Folio FA318 and Dwg D3145	RM	05/04/10	11
4	QC2	Inspect parts as they come off the CNC machine	RM	05/04/10	11
5	MV	Deburr and Tumble	RM	05/04/27	11
6	QC5	Second inspection	ER	05/04/27	11
7	FP	Chemical Conversion Coat per QSI 005 4.1	FT	05/5/2	11
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	ML	05.05.02	11
9	QC3	Inspect work to Step 8	CL	05/05/03	11
10	ST	Identify and Stock	CL	05/05/03	11
11	AC	Cost / part 71.87	54r	05-05-05	11
12	DC	Close W/O 69.90 Inspect Level 21	FA	05.05.11	11

Rev	Date	Change	Revised By	Approved
A	03.02.28	New issue	KJ/RF	FA

RELEASED
03.03.04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/00	3	2 pieces, 1 slot was off of .007" 1 piece, 1 slot was off of .006"	 05.04.27	 ELONGATE SLOT SO THAT EDGE DISTANCES ARE SIMILAR FOR PIECE THAT IS 0.020" OFF. 0.007" PIECE IS OK.	 05/04/27	 05-04-27	 05-04-27	 05-04-27

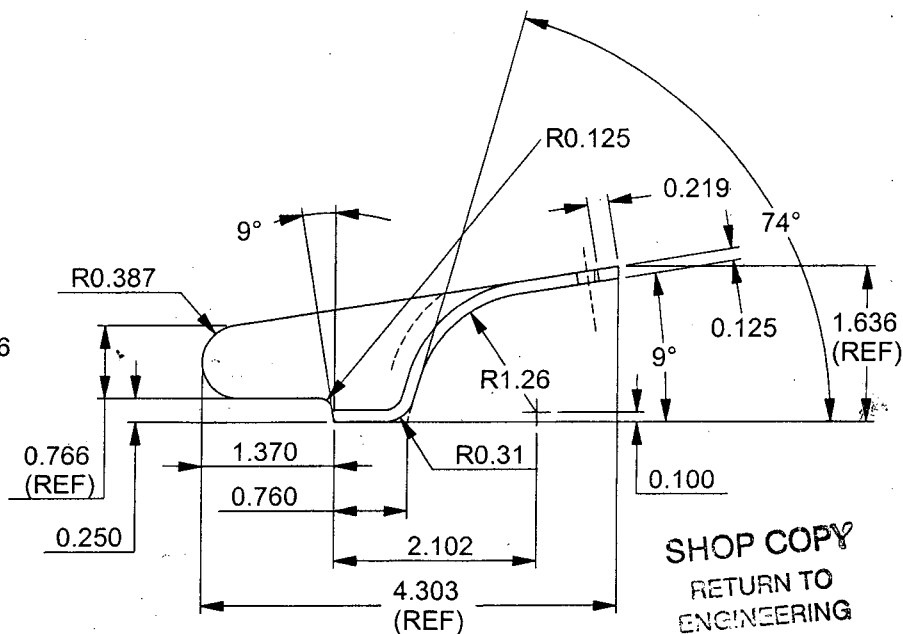
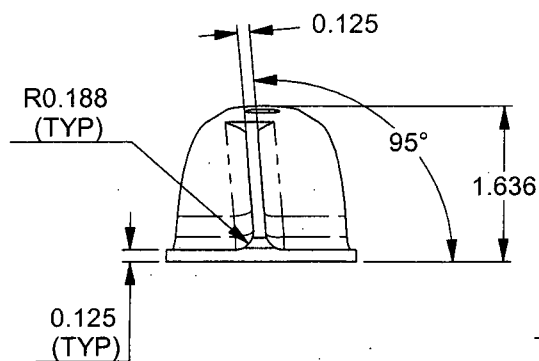
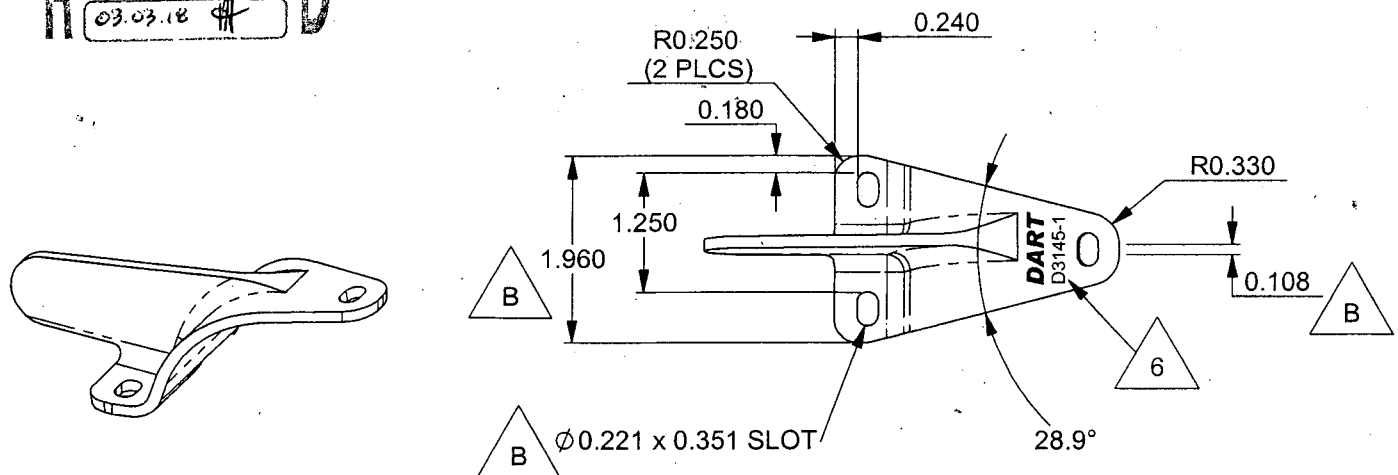
Part No: D3145-2 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05-05-00

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>RF</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22501

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 21, 2005
07:40 am

Work Order No : 0022501
Project Name : D3145-2
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : D3145-2
Description : Bracket
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 02-18-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22501
Description: BRACKET		Part Number: D3145-2
Inspection Dwg: D3145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.188	$\pm .010$	R0.188	✓		R-G	
0.125	$\pm .010$	0.122	✓		Vern	
1.636	$\pm .010$	1.643	✓		H-G	
0.125	$\pm .010$	0.123	✓		Vern	
0.766	$\pm .010$	0.766	✓		Vern	
0.250	$\pm .010$	0.248	✓		Vern	
1.370	$\pm .010$	1.370	✓		Vern	
0.760	$\pm .010$	0.760	✓		Vern	
4.303	$\pm .010$	4.305	✓		Vern	
0.125	$\pm .010$	0.132	✓		Vern	
0.219	$\pm .010$	0.209	✓		Vern	
R0.125	$\pm .010$	R0.125	✓		Vern	
1.960	$\pm .010$	1.962	✓		Vern	
1.250	$\pm .010$	1.250	✓		Vern	
0.180	$\pm .010$	0.183	✓		Vern	
R0.250	$\pm .010$	R0.250	✓		R-G	
0.240	$\pm .010$	0.232	✓		Vern	
0.108	$\pm .010$	0.110	✓		Vern	
0.221 X 0.351	$\pm .010$	0.222 X 0.350	✓		Vern	

Measured by: JML	Audited by: SA	Prototype Approval: N/A
Date: 05/04/10	Date: 05/04/10	Date:

Rev: A	Date:	Change: New Issue	Revised by: KJ/JLM	Approved:
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